



PRODUCT DATA SHEET

CrackFil

Crack Filling Putty

GENERAL DESCRIPTION

DUROMAR CRACKFIL is a fast curing, 100% solids epoxy, which is designed to be used as a crack sealing compound. It is used primarily to fill and repair cracks in order to create a flat surface. It can be overcoated with any of the other **DUROFLOR®** linings or maintenance products.

FEATURES

- Fast curing
- Cures at temperatures as low as 40°F
- No toxic fumes
- Good bond strengths
- Easy to Apply

PACKAGING

CRACKFIL is available in ¼ kg. kits.

COVERAGE

CRACKFIL can be applied into small hairline cracks or larger, deeper cracks. Due to the variation in size of the cracks, it is difficult to approximate coverage. Theoretically, if the cracks averaged 1/2" deep and 1/8" wide, one kit would fill 640 linear feet. Different sized cracks will change the linear foot coverage.

MIXING RATIO

3 parts base (B) to 2 parts (A) hardener by weight

5 parts base (B) to 4 parts (A) hardener by volume

POT LIFE

Working time of material in static mixer is 8 minutes.

COLORS

CRACKFIL is opaque in color.

TECHNICAL DATA AND INFORMATION

Basic Chemical Resistance at Room Temperature:

| | |
|-----------------|-----------|
| Inorganic Acids | Very Good |
| Organic Acids | Very Good |
| Solvents | Excellent |
| Alkalis | Excellent |
| Salts | Excellent |
| Alcohols | Good |
| Hydrocarbons | Good |

Typical Physical Properties of Cured System:

| | |
|-------------------------|-----------|
| Density | 1.08 |
| % Solids | 100 |
| Tensile Strength @ 70°F | 7,000 psi |
| Max. Dry Operating Temp | 250°F |
| Operating pH Range | 2.0-14.0 |
| Durometer Shore D | 80 |

SURFACE PREPARATION

- For maximum adhesion, material should be applied to a firm, clean, dry and abraded surface.
- Best results will be obtained by abrasive blasting the surface.
- If blasting is impractical, a grinding wheel, needle gun, or very stiff wire brush may be used.
- Clean greasy, oily or waxed surfaces with suitable solvent before applying material.

MIXING

Mix ALL of Part A with ALL of Part B in the Part B bucket. If the materials are cold, warm them to about 70°F before mixing.

CLEANUP

Most solvents and commonly used thinners such as MEK, acetone, xylene, 1,1,1 trichloroethane, and safety solvents such as Ensolv, etc., can be used for cleaning tools and equipment. However, as many of these materials are flammable or present other safety hazards, the user should read the MSDS for these materials before using. In no event should these materials be used to clean material from the skin, eyes or clothing.



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APPLICATION

CRACKFIL should be applied over the **DUROFLOR® SEALER**. **CRACKFIL** may be applied by hand, using a small trowel or putty knife. Press material thoroughly into the substrate and build up to meet the desired thickness. Smooth over to create the desired surface.

- Min. Thickness/Coat (mils) 30
- Max. Thickness/Coat (mils) 2000
- Number of Coats 1-2
- Min. Application Temperature 40°F

For best results, do not apply:

- To oily surfaces

OVERCOATING

CRACKFIL can be overcoated to obtain additional chemical resistance. Overcoating can be done as soon as the surface will not be disturbed by the overcoating process. Since the **CRACKFIL** is quick curing, the overcoating can be done almost immediately.

CRACKFIL Overcoating Window

| 55°F | 70°F | 85°F |
|------|------|------|
| | 1-24 | |

CURING @ 70°F

- Tack Free (hours) 2
- Functional Cure (hours) 8
- Full Cure (hours) 48

Q/C

The material should be visually inspected just after application and touched up where necessary.

FORCE CURING

Force cures are recommended for severe service conditions as both the physical and chemical properties are enhanced. Force curing should not start until material has firmly set.

Recommended Force Cure Schedule:

- Full Cure 4 hours @ 180°F
- Functional Cure 8 hours @ 120°F

STORAGE/SHELF LIFE

Store in dry area in closed containers between 50°F and 110°F. Shelf life at these conditions is greater than one year.

HEALTH AND SAFETY

READ AND UNDERSTAND ALL MATERIAL GIVEN IN THE MSDS SHEETS BEFORE USING THE PRODUCT.

CRACKFIL DOES NOT CONTAIN ANY FLAMMABLE MATERIAL OF ANY KIND. HOWEVER, THE MATERIAL IS COMBUSTIBLE. IN THE EVENT OF A FIRE, DRY POWDER, FOAM, OR CARBON DIOXIDE FIRE EXTINGUISHERS SHOULD BE USED. FIRE FIGHTERS SHOULD WEAR RESPIRATORS.

USE PROTECTIVE GLOVES AND EYEGLASSES WHEN USING.

USE IN AREAS OF GOOD VENTILATION.

LIMITED WARRANTY

All recommendations covering the use of this product are based on past experience and laboratory findings. Methods or conditions of application and use of the product are beyond our control. We assume responsibility only for the uniformity of our product within normal manufacturing balances.

All Duromar products are formulated based on over 25 years of experience, laboratory tests, material data, field installations, and technical publications, which we believe to be, to the best of our knowledge, accurate and reliable. This information is intended to be used for guidance only. Because the only true reliable test is one that is in actual operation, Duromar will make available at no charge samples of materials for that testing purpose. Duromar, Inc. has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Duromar, Inc. does, therefore, not accept any liability arising from loss, injury, or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise). The data contained herein is liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues, and it is, therefore, the user's responsibility to ensure that this sheet is current prior to using the product.

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